

SHIP 20/01

# Work Order ID 55390

January 15, 2010 9:11:45 AM



Item ID: D3230-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Basket Wedge Assembly

Start Date: 1/15/10 Start Qty: 1.00



Cust Item ID:

Required Date: 1/20/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3230

Rev C

110

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut 3/4 x 3/4 square tubing as per Dwg D3230  
2- Drill and c/sink holes  
3- cut mesh as per dwg  
4 -Deburr & Remove all Markings From Material  
5-Weld bushings and fabricate basket wedge assembly as per D3230  
A/R SS ROD Batch: M109213

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

SY 10/01/19 (1x)

D 10.01.19 (1)

# Work Order ID 55390

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Item ID: D3230-041

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Revision ID:

Stop

Item Name: Basket Wedge Assembly

Start Date: 1/15/10 Start Qty: 1.00

Cust Item ID:

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Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date:

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Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

140

\*PRESSURE-WASH  
White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Powdercoat

Memo

0.00

Powder Coating

IST COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

\*\*\*\* if necessary\*\*\*\*

2ND COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

2> 8/10/17

(4L)

=> 10/01/19

(XU) 8

1:00pm  
400°F  
1:30pm

2:00pm  
400°F  
2:30pm

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Required Date: 1/20/10 Req'd Qty: 1.00

Customer:

Reference:

Run Start

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

QC3- Inspect Part Finish

0.00

BK 10-01-10

① ①

QC

Memo

0.00

Quality Control

180

Identify as per dwg & Stock Location

0.00

Packaging

Memo

PNP  
DS19268-04

0.00

Packaging

Packaging

10/01/20 ①

190

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/01/20  
MF 10-1-20

# Picklist Print

January 15, 2010 9:11:44 AM

Page 1  
13

Work Order ID: 55390

Parent Item: D3230-041

Parent Item Name: Basket Wedge Assembly

Comments: IPP Rev:D 09-02-25 rev.c as per dwg DD verified by:EC

Start Date: 1/15/10

Required Date: 1/20/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2232-3 Manufactured No

110 Each 37.0000 2.0000



Basket Hinge

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 30

50024 2

54863 28

Main Warehouse

WA 7

53831 7

D2327-3 Manufactured No

110 Each 29.0000 2.0000



Spacer Bushing

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 29

44274 4

44365 9

54135 16

2x 10/01/18

2x 10/01/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

January 15, 2010 9:11:44 AM

Page 2

Work Order ID: 55390

Parent Item: D3230-041

Parent Item Name: Basket Wedge Assembly

Start Date: 1/15/10

Required Date: 1/20/10

Comments: IPP Rev:D 09-02-25 rev.c as per dwg DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3759-1		Manufactured	No			110	Each	71.0000	5.0000			



Bushing

Warehouse  
Location

Main Warehouse

WA

71

53442

2

54072

29

55093

40

M304EX0.75-16F

Purchased

No

110

sf

1,189.675 5.4211



Expanded Metal Flat SS

Warehouse  
Location

Main Warehouse

MAT

1189.675006

110134

3.4

111956

0.000017

112147

9.4736E-06

112949

43.42358

113205

0.0093

113497

292.8421

113555

850

SV 24 10/01/18

SAD 10-01-18

5.4211

January 15, 2010 9:11:44 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

January 15, 2010 9:11:45 AM

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Work Order ID: 55390



Parent Item: D3230-041



Parent Item Name: Basket Wedge Assembly

Start Date: 1/15/10

Required Date: 1/20/10

Comments: IPP Rev:D 09-02-25 rev.c as per dwg DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304TS0.750W.065		Purchased	No			110	f	185.0113	26.6280			



304 SQ Tube .75x.75x.065W



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	185.0112742	
113082	0.00419	
113245	185.007084	
Main Warehouse		
WA	0.0000047	
112398	0.0000047	

26.6280

10/01/18

1 feet END BAR  
SCRAP



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3230-041	BASKET WEDGE ASSEMBLY
3	1	D2221-1	RIB
4	2	D2232-3	BASKET HINGE
5	2	D2327-3	SPACER BUSHING
6	1	D3230-1	RIB
7	1	D3230-2	RIB
8	1	D3230-3	RIB
9	1	D3230-4	RIB
10	4	D3230-5	RIB
11	1	D3230-7	RIB
12	2	D3230-9	SIDE MESH
13	1	D3230-11	FRONT MESH
14	5	D3759-1	BUSHING

**D3230-041 BASKET WEDGE ASSEMBLY**  
(MESH SHOWN LOCALLY FOR CLARITY)

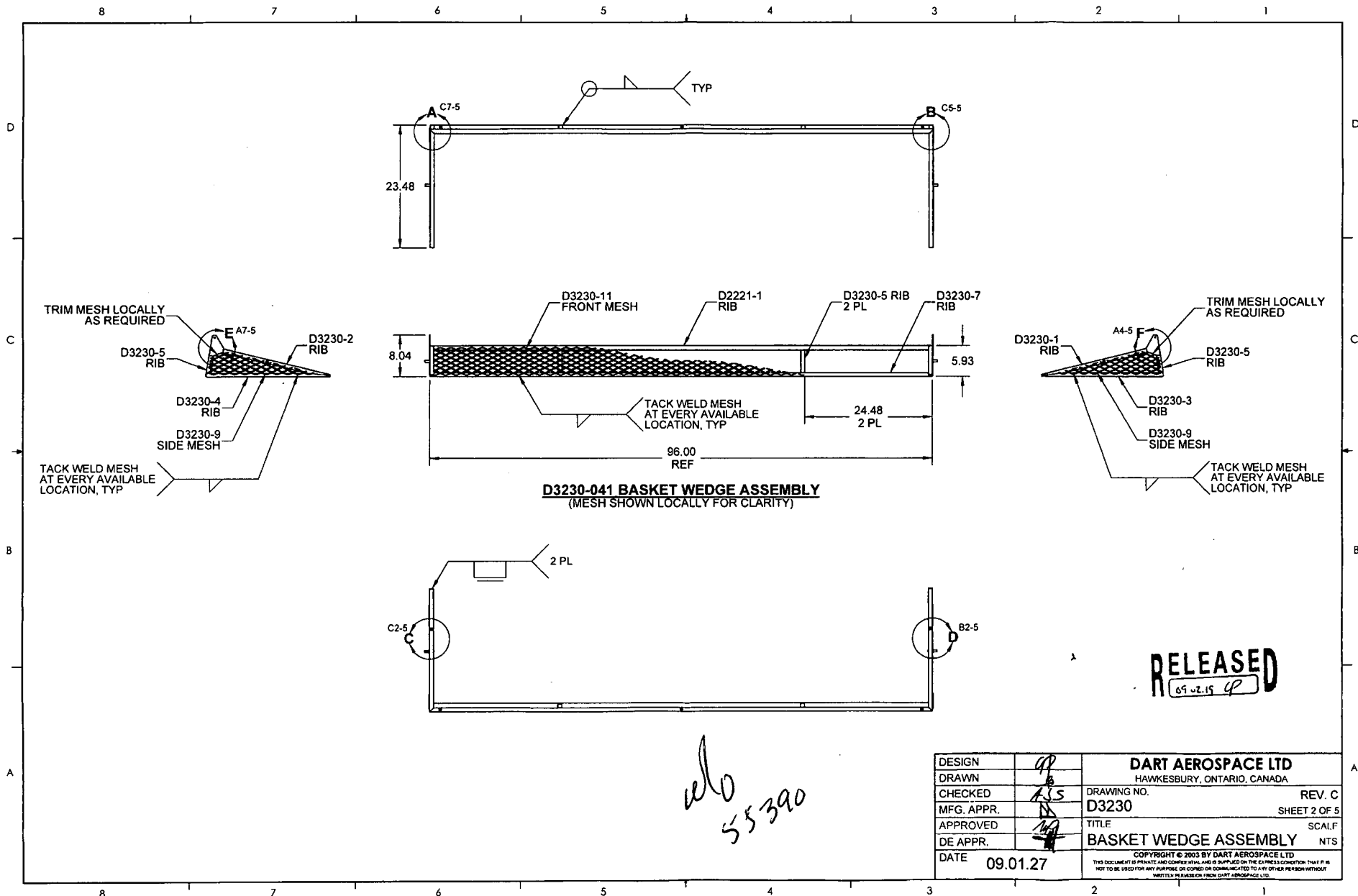
Wb 55390

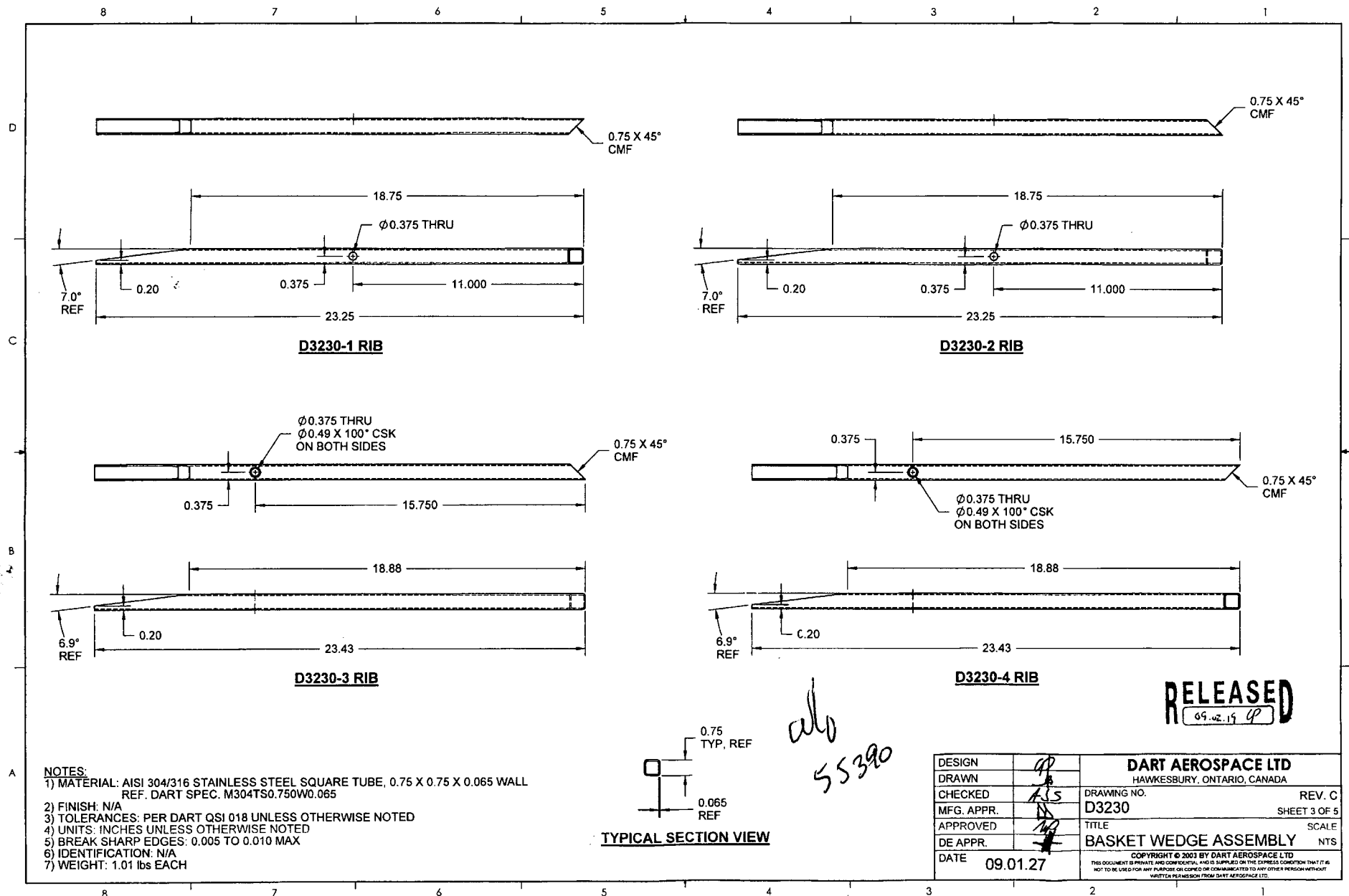
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09.02.19 CP  
PER ECN 09-534

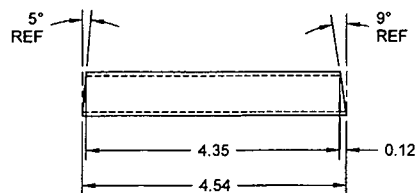
C	REDESIGN (SEE NCR 09-010); REFORMAT DRAWING TO CURRENT STANDARDS	MB	09.01.27
B	15.75 WAS 16.00; REMOVE D2581; ADD VIEW B-B; D2327-3 ADDED	CB	06.11.10
A	NEW ISSUE	CP	03.10.31
REV.	DESCRIPTION	BY	DATE
DESIGN	CP		
DRAWN	AS		
CHECKED	AS		
MFG. APPR.	AS		
APPROVED	AS		
DE APPR.	AS		
DATE	09.01.27		
<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D3230</b> TITLE <b>BASKET WEDGE ASSEMBLY</b> SHEET 1 OF 5 SCALE NTS COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

**NOTES:**

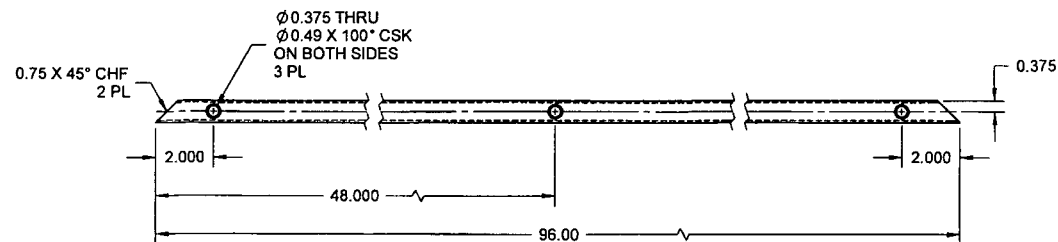
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3230-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 19.8 lbs
- 8) WELDING: PER DART QSI 004



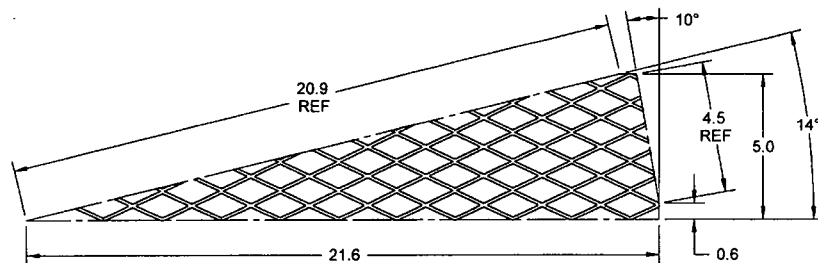




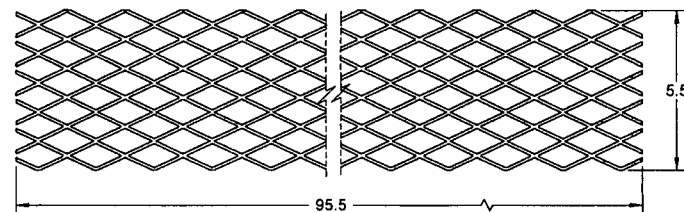
**D3230-5 RIB**



**D3230-7 RIB**



**D3230-9 SIDE MESH**









**D3230-11 FRONT MESH**

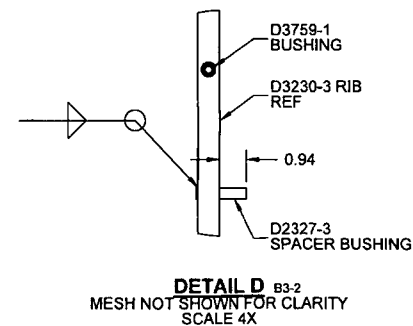
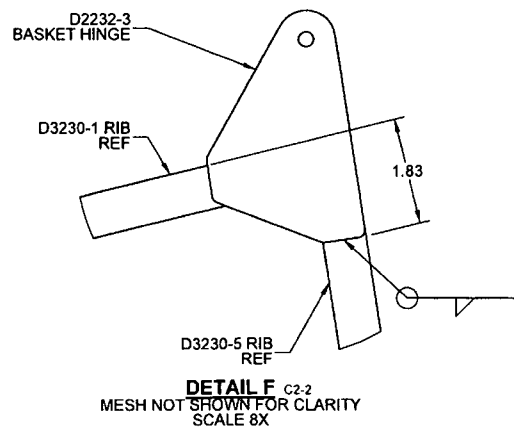
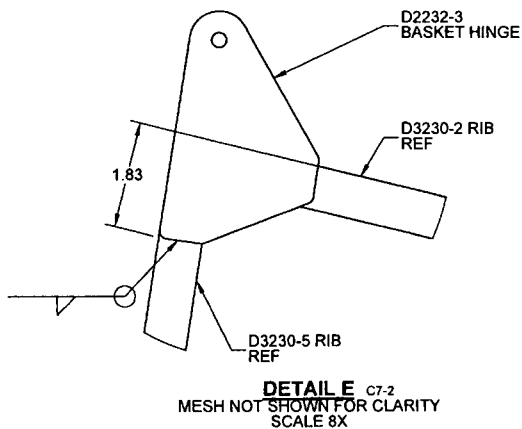
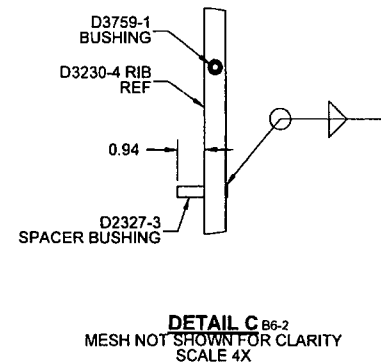
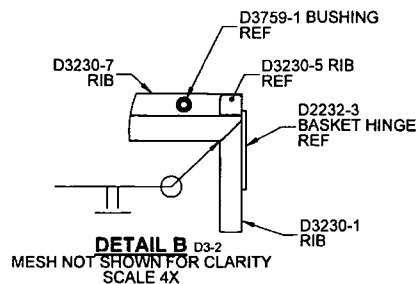
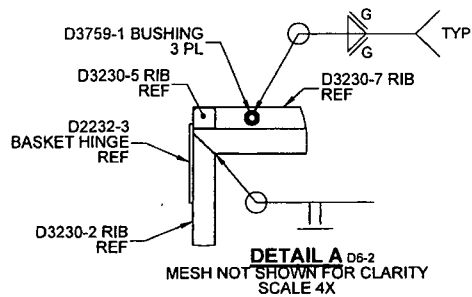
**NOTES:**

- 1) MATERIAL:  
D3230-5/-7: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL  
REF. DART SPEC. M304TS0.750W0.065  
D3230-9/-11: 3/4-16F EXPANDED STAINLESS STEEL  
REF. DART SPEC. M304EX0.75-16F
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3230-5 = 0.21 lbs; D3230-7 = 4.55 lbs  
D3230-9 = 0.20 lbs; D3230-11 = lbs

**RELEASED**  
09-22-19 4P

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		<b>D3230</b>	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		<b>BASKET WEDGE ASSEMBLY</b>	NTS
DATE	<b>09.01.27</b>	COPYRIGHT © 2003 BY DART AEROSPACE LTD	
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WLO  
55390



**RELEASED**  
09-21-84

DESIGN	4P	<b>DART AEROSPACE LTD</b>	
DRAWN	AS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. C
MFG. APPR.	AS	<b>D3230</b>	SHEET 5 OF 5
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	<b>BASKET WEDGE ASSEMBLY</b>	
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